Date:

Tuesday, 23/12/2008 12:53:23 PM

User:

Linda Lacelle

**Process Sheet** 

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Estimate Number

, 'k

Job Number : 44278 : 10725

P.O. Number

This Issue : 23/12/2008

Prsht Rev. : NC

First Issue : //

: 43900 Previous Run

Written By

Checked & Approved By

Comment

: Est Rev:B 02.06.13

Type

: MACHINED PARTS

Part Number **Drawing Number** 

**Drawing Name** 

: D2652 : D2652 REV A

: N/A

: A

: BUSHING

**Project Number** 

**Drawing Revision** 

Material **Due Date** 

NG

: 05/01/2009

Qty:

300 Um:

Each

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0

2.0

M303R0500

303 Round Bar 0.500"

Now machined in house.

Comment: Qty.:

0.0578 f(s)/Unit Total: 17.3250 f(s)

Material:303 ss .500" Round Bar

(M303R0500)

Batch: //o ZS-2

J.F./ \$ 08/12/29

HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA250 & DWG D2652

FOLIO REV: A DWG REV: AA

2-DEBURR AS REQUIRED

INSPECT PARTS AS THEY COME OFF MACHINE





300 pcs

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

3.0

QC8

QC2

SECOND CHECK



Comment: SECOND CHECK

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



Dart Ae	rospace Ltd							
W/O:			WORK ORDER	CHANGE\$				
DATE	STEP	PR	PROCEDURE CHANGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					,			
			····					
Part No	:	PAR #:	Fault Category:	NCR: Y	es No DQ	A:	_ Date: _	
	Resolution	on:	Disposition:	QA: N/0	Closed:		Date:	
NCR:			WORK ORDER NON-CON	IFORMANCE (N	CR)			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section	Verification	Ammuousi	<b>A</b>			
DATE	STEP	STEP Description of NC Section A		Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
		<u> </u>								
	:									

NOTE: Date & initial all entries

Date: User:

Tuesday, 23/12/2008 12:53:23 PM

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: BUSHING** 

Job Number: 44278

Part Number: D2652

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Ae	rospace Ltd								
W/O:			WORK ORDER (	CHANGES					
DATE	STEP	PRO	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			â						
Part No			Fault Category:					Date: _	
	Resolut	ion: <u>·</u>	Disposition:	QA:	N/C C	Closed:		Date: _	
NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
		7.00							

NCR:		\	WORK ORI	DER NON-CONFORMAI	NCE (NCR)			
		Description of NC	1	Corrective Action Section	!	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
		·		; •				

NOTE: Date & initial all entries

Work Ordon	W1229
Work Order:	44278
Part Number:	D2652
	Page 1 of 1
	Work Order: Part Number:

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

					- 7   -	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.600	+/-0.010	, 599				
0.060	+/-0.005	00585	/			
Ø0.305	-0.002/+0.000	. 3035	/			
Ø0.191	+0.005/-0.000	·193	1			
Ø0.500	+/-0.010	.494				
0.030 x 20°	+/-0.010	€030 ×20°				
R0.010	+0.010/-0.000	. 610				
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	I,			1		

Measured by:	湖	Audited by:	JL	Prototype Approval:	N/A
Date:	08/12/28	Datë:	08/2/29	Date:	

<u>Rev</u>	Date	Change	Revised by	Approved
A	03.12.12	New Issue	KJ/RF	
	-		<del>[                                    </del>	<b>T</b>





DESIGN	DRAWN BY
B.	APPROVED DID
DATE	

97:03:25

DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA

DRAWING NO. D2652

REV. A

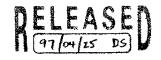
SHEET 1 OF 1

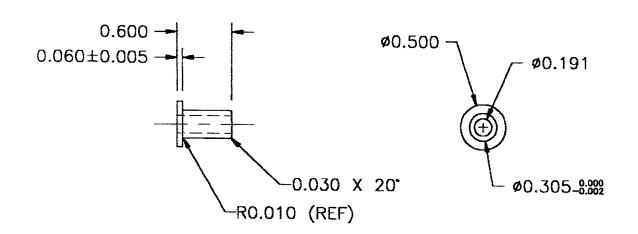
SCALE

**BUSHING** 

TITLE

w/ 44278





MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART OST 018 UNLESS OTHERWISE NOTED